

Date: Friday, 09/05/2008 1:45:19 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT ASSEMBLY
Job Number : 39152	
Estimate Number : 10732	
P.O. Number :	Part Number : D23241
This Issue : 09/05/2008 S.O. No. :	Drawing Number : D2324 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 36749	Material :
Written By :	Due Date : 05/06/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUL 08.5.09</u>	
Comment : Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K J/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	39152A	STOP
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**Comment:** Sub-Component STOPD2324-3 B 36749A

CB08/05/12

2.0	39152B	STRAP
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**Comment:** Sub-Component STRAPD2324-5 B B 37631

CB08/05/12

3.0	AN312A	Bolt
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)Bolt M103947 (7x)M106605 (33x)

CB08/05/12

4.0	AN960JD10	Washer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer

M107715

CB08/05/12

5.0	MS21042L3	Nut
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

M107644

CB08/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT ASSEMBLY

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2324.

EB 08/05/12

(20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/12 x 20

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m/07550

(PB) →

START TIME:

10:50

OVEN TEMPERATURE:

320

FINISH TIME:

11:20

FL 08/05/13

(23)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

S 08/05/14 (420)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST 203*

JS 08/05/14

(22)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/15

Job Completion



W 08/05/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

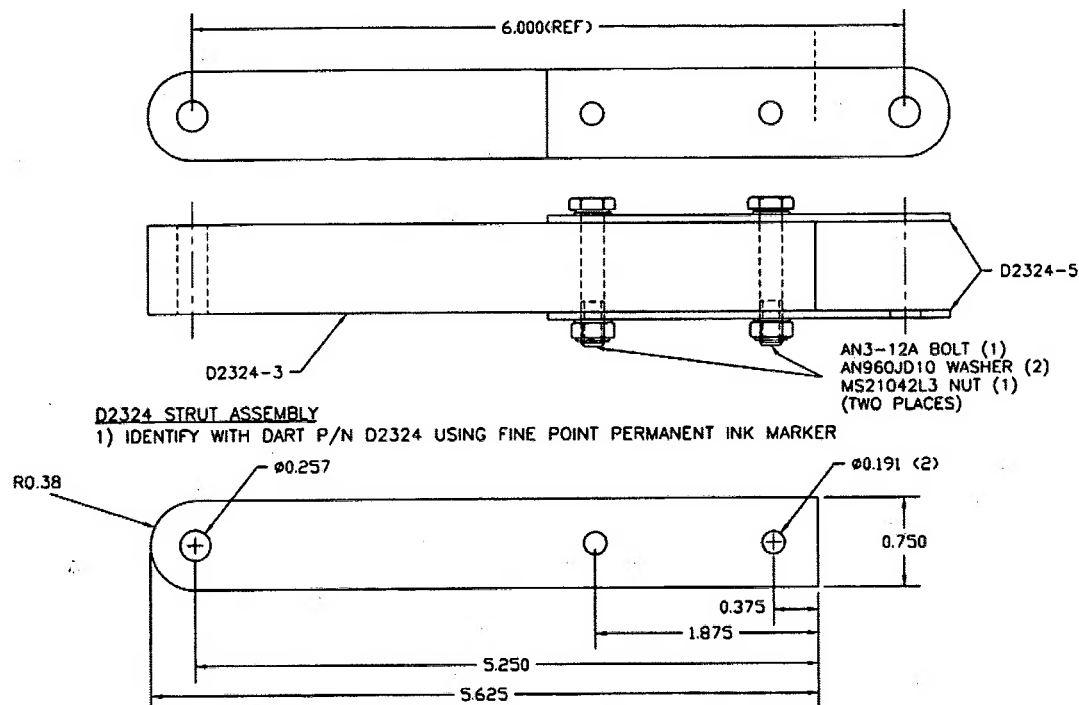
Part No: D2324-1 PAR #: NA Fault Category: Prod/Finishing NCR: Yes No DQA: D Date: 08/05/15
 QA: N/C Closed: D Date: 08/05/15

NCR: 39152		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/13	8.0 6.0	During Powder coat inspection it was found that one strut has a large scratch on it.	[Signature]	Buff out Buff out scratch	SJS 03/05/13	[Signature]	[Signature]	08/05/13
				Re Alodine Alodine affected area Start time: 2:25 Temp: 320° Finish time: 2:55. Re Powder coat as per QST005	SJS 08/05/13 08/05/13			
			[Signature]	FRAN3-124 M106605 FRAN3-124 M106605 FRMS21042 L3 M107644 Remove and Replace Hardware	SJS 09/05/13	[Signature]	[Signature]	8/05/13

NOTE: Date & initial all entries

DART

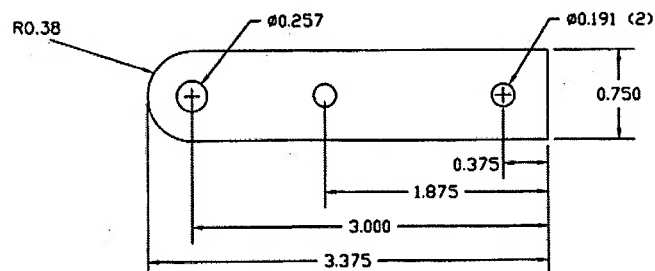
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 39152

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries